

Work Order ID 86106

June-20-12 2:51:16 PM

86106

Page 1

Item ID: D3245-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door

Start Date: 20/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/20* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3245

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3245 Dwg Rev: *C* Prog Rev: *C* 2-
Deburr if necessary

304 . 032

10 0 Jm 12-6-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 Jm 12-6-23

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10 M 12 06 24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

June-20-12 2:51:16 PM

Page 2

Accept

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

10

10

Customer:

Reference:

Run Start *NR1*

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Insp.
Stamp

130

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Deburr if necessary, buff entire surface to ensure a nice surface finish. Form D3245-3 as per Dwg D3245 Identify as D3245-3

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 50 GA 0.00

0.00

150

Packaging

Memo

0.00

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 86106

June-20-12 2:51:16 PM

86106

Page 3

Item ID: D3245-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Door

Stop ***NS2***

Start Date: 20/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/7/18

MF
12-07-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

June-20-12 2:51:20 PM

Page 1

Work Order ID: 86106

86106

Parent Item: D3245-3

D3245-3

Parent Item Name: Door

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A04.07.07New issueKJ/JLM
IPP Rev:B Now on Waterjet 07-09-14 JLM Verified By:EC
IPP Rev:c ECN 1052 07-10-31 DD verified by:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S22GA | | Purchased | | No | | 100 | sf | 236.9900 | 0.537 | 5.652632 | | | |

M304S22GA

304/316 .032 Sheet

**

Jan 12-6-23

Location

Loc Qty

Loc Code

MAT020

236.99

118271

8.88

120866

74.36

121889

153.75

120866

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

SHOP COPY

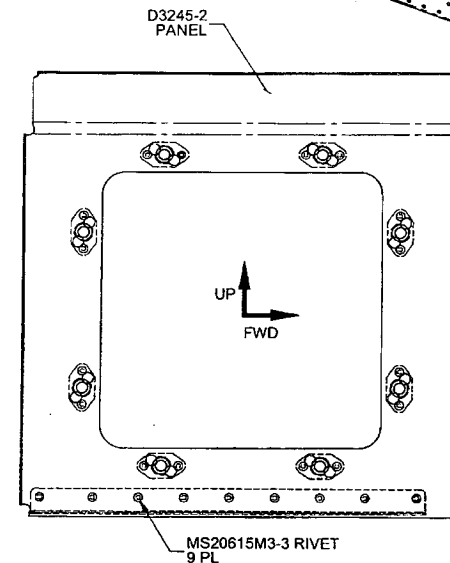
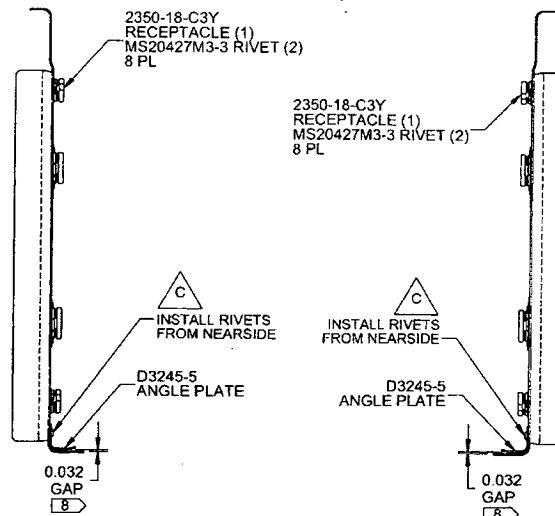
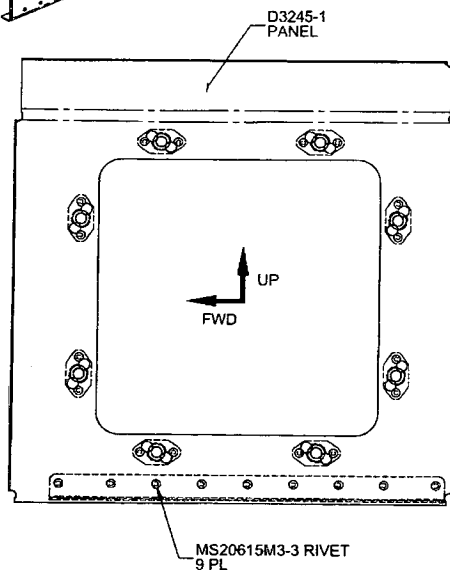
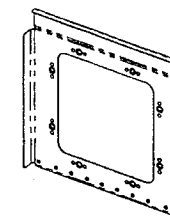
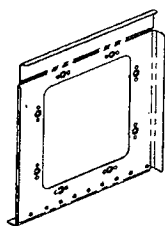
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 86106 MJS
12/06/20

D3245-041 ACCESS PANEL ASSY (LH)

D3245-042 ACCESS PANEL ASSY (RH)



| QTY -041 | QTY -042 | P/N | DESCRIPTION |
|----------|----------|-------------|------------------------|
| X | | D3245-041 | ACCESS PANEL ASSY (LH) |
| | X | D3245-042 | ACCESS PANEL ASSY (RH) |
| 1 | | D3245-1 | PANEL |
| 1 | 1 | D3245-2 | PANEL |
| 1 | 1 | D3245-5 | ANGLE PLATE |
| 8 | 8 | 2350-18-C3Y | RECEPTACLE |
| 16 | 16 | MS20427M3-3 | RIVET |
| 9 | 9 | MS20615M3-3 | RIVET |

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.83 lbs
- 8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL

| C | ADDED NOTE 8, SHEET 1, SPECIFIED RIVET ORIENTATION (B4-1, B5-1), CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.098, 9 PLACES (D6-6). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165. | RP | 12.04.11 |
|------------|---|----|----------|
| B | REMOVE 0.0204 HOLES FROM D3245-11-1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING. | MB | 07.10.02 |
| A | NEW ISSUE | RF | 04.01.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | | |
| DRAWN | MB | | |
| CHECKED | A.P. | | |
| MFG. APPR. | [Signature] | | |
| APPROVED | [Signature] | | |
| DE APPR. | [Signature] | | |
| DATE | 12.04.11 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3245** REV. C
SHEET 1 OF 7
TITLE **ACCESS PANEL ASSY** SCALE **NTS**

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2012-05-07

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

D3245-3 DOOR

2351-20-012-C3Y STUD
127H-35 GROMMET
8 PL8.00
REF

8.00 REF

D3245-7 GASKET
REFINSTALL D3245-7
GASKET ON THIS SIDE
6

86106

D3245-043 DOOR ASSY

| QTY -043 | P/N | DESCRIPTION |
|-------------|-----------------|-------------------|
| X | D3245-043 | ACCESS PANEL ASSY |
| 1 | D3245-3 | DOOR |
| 1 | D3245-7 | GASKET |
| 8 | 127H-35 | GROMMET |
| 8 | 2351-20-012-C3Y | STUD |

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

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2012-05-07

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| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | MB | | |
| CHECKED | AP | DRAWING NO. D3245 | REV. C |
| MFG. APPR. | JP | TITLE ACCESS PANEL ASSY | SHEET 2 OF 7 |
| APPROVED | JP | SCALE | NTS |
| DE APPR. | JP | COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 12.04.11 | | |

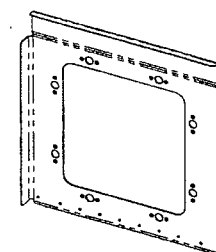
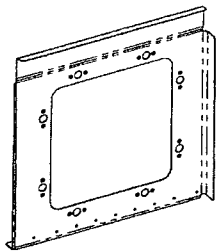
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

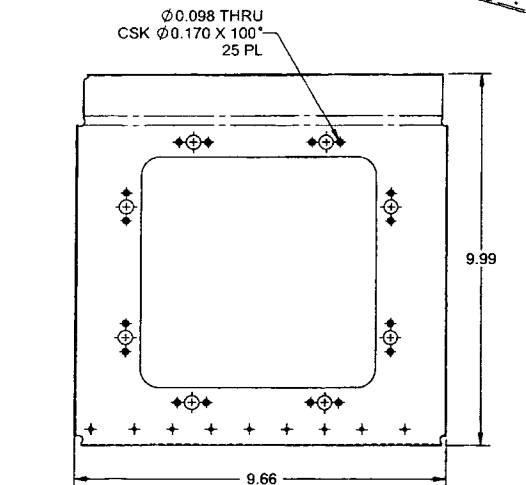
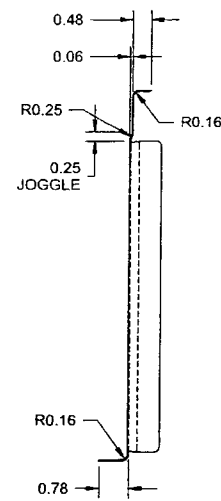
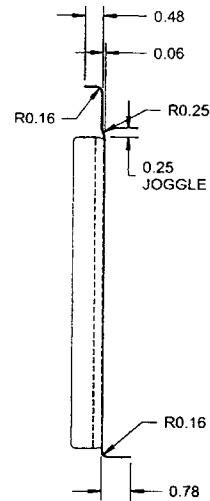
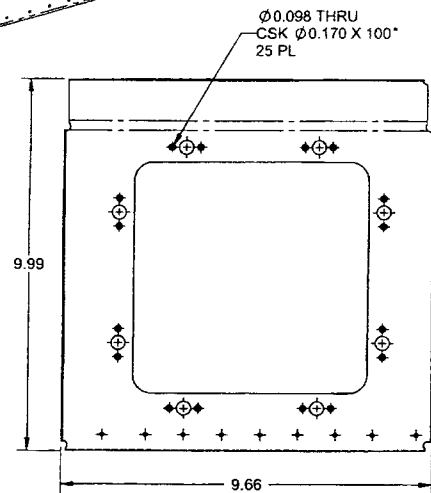
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NOTE: Date & initial all entries



86106



D3245-1 PANEL (LH)

D3245-2 PANEL (RH)

NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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2012-05-07

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| DRAWN | MB | | |
| CHECKED | AP | DRAWING NO. | REV. C |
| MFG. APPR. | | D3245 | SHEET 3 OF 7 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | ACCESS PANEL ASSY | NTS |
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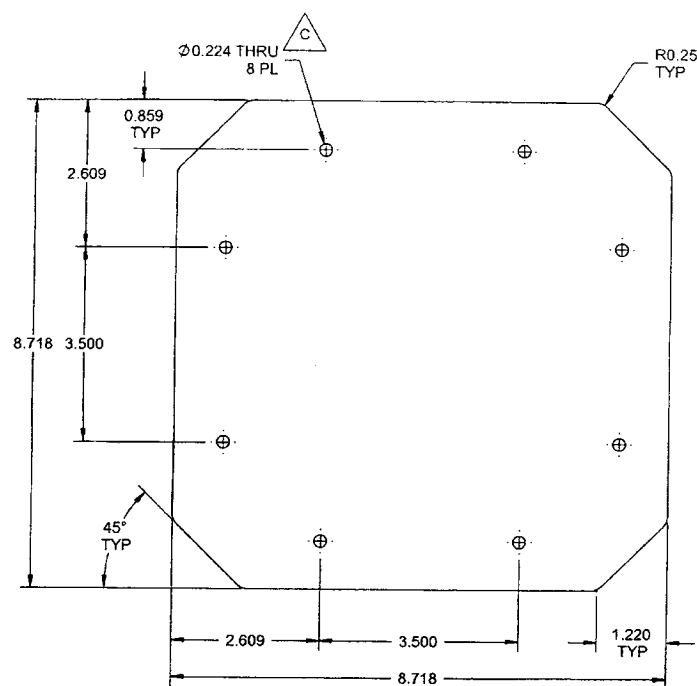
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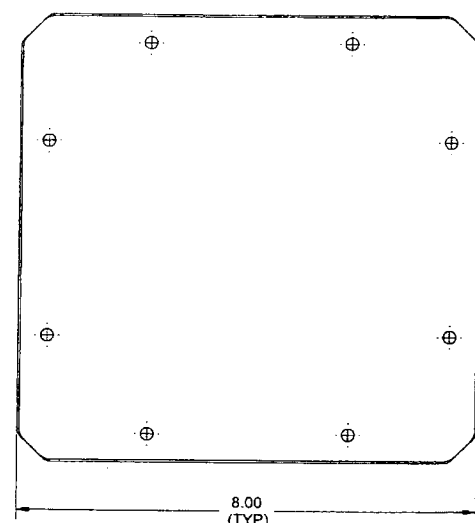
NOTE: Date & initial all entries

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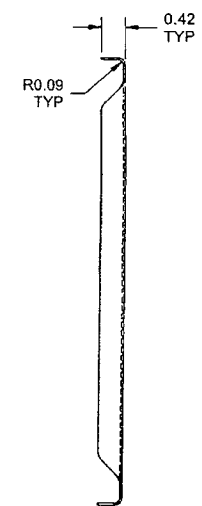
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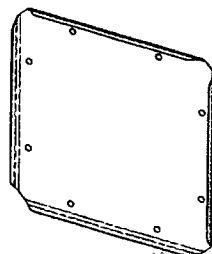
D3245-3F DOOR FLAT PATTERN



**D3245-3 DOOR
(MADE FROM D3245-3F)**



- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.66 lbs



RELEASED
2012-05-07

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| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | MB | | |
| CHECKED | A.P. | DRAWING NO. D3245 | REV. C |
| MFG. APPR. | | | SHEET 5 OF 7 |
| APPROVED | | TITLE | SCALE |
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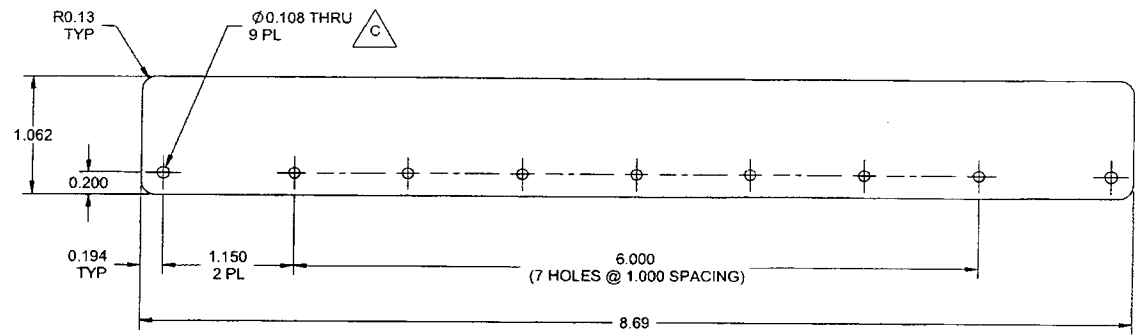
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

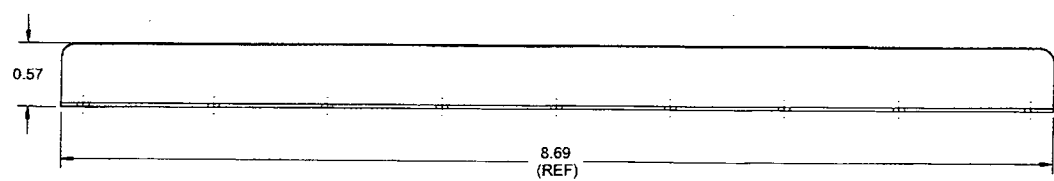
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

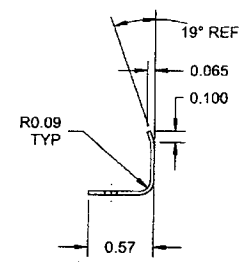
86106



D3245-5F FLAT PATTERN



D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)



REL. 1020
2012-05-07

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

| | | | |
|---|----------|--|--------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | MB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AV | DRAWING NO. D3245 | REV. C |
| MFG. APPR. | ED | SHEET 6 OF 7 | |
| APPROVED | AV | TITLE | SCALE |
| DE APPR. | AV | ACCESS PANEL ASSY | NTS |
| DATE | 12.04.11 | COPYRIGHT © 2014 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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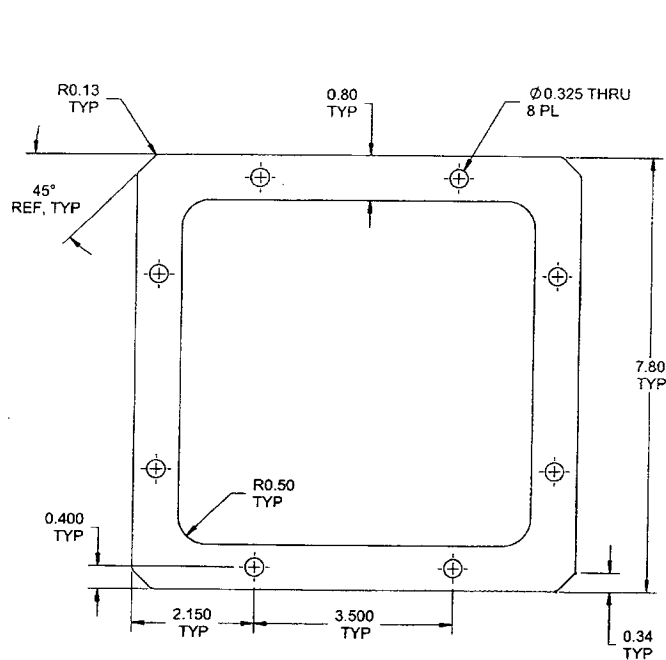
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

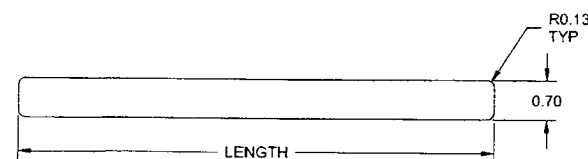
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

86104



D3245-7 GASKET



D3245-X GASKET

| P/N | LENGTH |
|----------|--------|
| D3245-9 | 8.35 |
| D3245-11 | 9.01 |
| D3245-13 | 9.50 |

NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | MB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AD | DRAWING NO. | REV. C |
| MFG. APPR. | AD | D3245 | SHEET 7 OF 7 |
| APPROVED | AD | TITLE | SCALE |
| DE APPR. | AD | ACCESS PANEL ASSY | NTS |
| DATE | 12.04.11 | COPYRIGHT © 2004 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries